

6061 1.500
Work Order ID 99960

Tuesday, April 16, 2013 3:47:33 PM

99960

Page 1

Item ID: PB67-43001-291

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Bushing

Start Date: 4/16/2013 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/24/2013 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: *mw*

Date: *13-6-7*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn as per Folio FA 557 & Dwg B67-43001								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	Mill slot as per Dwg B67-43001								

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/16/2013 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 5/24/2013 Req'd Qty: 8.00 *Q*

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.00

Quality Control

140 QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

NCR: Yes / No

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Page 3

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Stop ***NS2***

Item Name: Clamp Bushing

Start Date: 4/16/2013 Start Qty: 8.00

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Cust Item ID:

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Customer:

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Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3-Inspect Part Finish

0.00


160

QC

Memo

0.00

Quality Control

J 4 13-6-07 170 Identify as per dwg & Stock Location: 5T386 0.00***170***

Packaging

Memo

0.00

Packaging

8X 13-06-28

180 QC21- Final Inspection - Work Order Release 0.00


180

QC

Memo

0.00

Quality Control

13/7/28 
MS 13-06-28

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 99960

Parent Item: PB67-43001-291

Start Date: 4/16/2013

Required Date: 5/24/2013

Parent Item Name: Clamp Bushing

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.08.26New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R1.500 /
6061-T6 Round Bar 1.50

Purchased

No

100

f

14.6260

0.1023

0.8614737

.500'

2013-04-11

Location

Loc Qty

Loc Code

MAT013

14.626

110167

3.954

123483

10.672

.500'

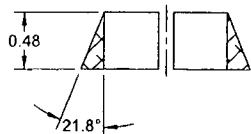
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

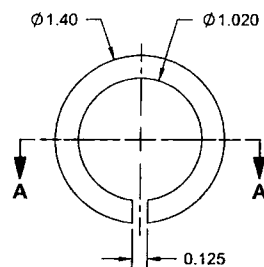
DQA: _____ Date: _____

QA Closed: _____ Date: _____

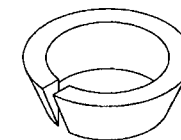
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SECTION A-A B6-1



B67-43001-291 CLAMP BUSHING C6-1



RELEASED
2009-09-24
WPD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 38 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.26
REV.		DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	<i>[Signature]</i>		DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>		B67-43001-291	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	N/A	CLAMP BUSHING	NT	
DATE	09.02.26		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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B67-43001-291

[illegible]

~~140P~~
13/06/26

10.04.15

